

Date: Wednesday, 2/8/2006 7:06:54 AM  
 User: Linda Lacelle

## Process Sheet

|   |                                     |
|---|-------------------------------------|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> : DOUBLER       |
| <b>Job Number</b> : 25733                             |                                     |
| <b>Estimate Number</b> : 11466                        |                                     |
| <b>P.O. Number</b> : N/A                              | <b>Part Number</b> : D314092        |
| <b>This Issue</b> : 2/8/2006 <b>S.O. No.</b> : N/A    | <b>Drawing Number</b> : D3140 REV C |
| <b>Prsht Rev.</b> : NC                                | <b>Project Number</b> : N/A         |
| <b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB | <b>Drawing Revision</b> : C         |
| <b>Previous Run</b> : N/A                             | <b>Material</b> : N/A               |
| <b>Written By</b> : SEE COMMENT BELOW                 | <b>Due Date</b> : 2/15/2006         |
| <b>Checked &amp; Approved By</b> : <u>u</u>           | <b>Qty:</b> 2 <b>Um:</b> Each       |
| <b>Comment</b> : Est. A02.04.30 New Issue NG          |                                     |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S032 | 2024-T3 .032 sheet |
|-----|-------------|--------------------|



**Comment:** Qty.: 0.1549 sf(s)/Unit Total : 0.3098 sf(s)  
 2024-T3 .032 sheet  
 Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick  
 ( M2024T3S.032 ) 5.00" x 4.06" flat pattern ref  
 Note grain direction

Batch

M18147

ml 06/02/09

|     |       |       |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



**Comment:** SHEAR  
 Cut as per dwg D3140

ml 06/02/09

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Deburr. No sharp edges  
 Notch out .75 x .40 corner as per dwg ( -91 shown )  
 Form as per dwg ( -91 shown )

make by hand

ml 06/02/09

SB 06/02/13 (2)

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

2-06-02-13 2

|     |                 |                            |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/15 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/21

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25733

Part Number: D314092

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06-02-15* *12*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:           

*06/02/20* *(2)*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*545 06/02/21* *(2)*

*06/02/21* *(2)*

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries